

Work Order ID 141990

Tuesday, February 23, 2016 11:22:59 AM

141990

Page 1

Item ID: D2747 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Set Screw
 Start Date: 2/23/2016 Start Qty: 50.00 ***50*** Cust Item ID:
 Required Date: 3/11/2016 Req'd Qty: 50.00 ***50*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: FEB 23 2016 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2747	Rev B								

100 PURCHASING 0.00
100
 Purchasing 0.00 50 FEB 23 2016 DAS 13 9-89
 Purchasing Memo
 Issue P/O: 31460 3/8"-24 UNF SS Set Screw 7/8" to 1"
 longPossible Supplie: McMaster CarrP/N:92311A639Material release note required

110 Receive & Inspect for Damage & Mat'l Certs 0.00
110
 Packaging 0.02 DAS 6 9-89 FEB 26 2016
 Packaging Memo
 Ensure material release note is attached

120 QC6- Inspect dimensions to drawing 0.00
120
 QC 0.00 (50) DAS 38 9-89
 Quality Control

FEB 26 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : ☐						
Misidentified ☐	☐	Past Due ☐							

Work Order ID 141990***141990***

Page 2

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Reference:

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>ST02A</u>	0.00							
130									
Packaging	Memo	0.01				<u>50</u>	<u>ML5</u>	<u>1602-29</u>	
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.08				<u>ML5</u>		<u>MAR 01 2016</u>	
Quality Control									

ML5 MAR 01 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____							
Misidentified ☐	☐ Past Due								

Picklist Print

Tuesday, February 23, 2016 11:23:02 AM

Page 1

Work Order ID: 141990

141990

Parent Item: D2747

D2747

Parent Item Name: Set Screw

Start Date: 2/23/2016

Required Date: 3/11/2016

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP: B05.08.22ReformatKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
92311A639		Purchased	No				Each	0.0000		50			
92311A639									**				
SS SET SCREW													

DAS
6
9-89

FEB 26 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

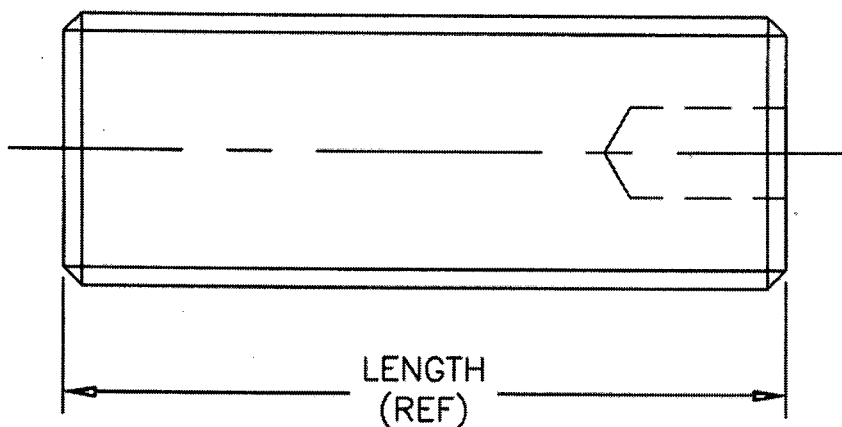
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐						
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval			
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY								
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process	OTHER : _____							
Misidentified ☐	☐	Past Due								



DESIGN DS	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2747	REV. B SHEET 1 OF 1
DATE 05.03.09		TITLE SET SCREW	SCALE NTS
A	98.08.26	NEW ISSUE	
B	05.03.09	REDRAWN, STAINLESS STEEL ONLY	

RELEASED
05.08.09 *[Signature]*



D2747 SET SCREW

- 1) TYPE: HEX SOCKET HEAD SET SCREW
- 2) MATERIAL: STAINLESS STEEL
- 3) THREAD: 3/8"-24 UNF
- 4) LENGTH = 7/8" TO 1"
- 5) FINISH: NONE
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

STOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 141990.415
1602123

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Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Purchase Order
PO31460
Order Placed By
Chantal Lavoie

Page 1 of 2
02/24/2016

McMaster-Carr Number
7543512-03

Line	Product	Ordered	Shipped
1	92198A672 18-8 Stainless Steel Hex Head Cap Screw, 7/16"-14 Thread, 5" Long, Packs of 1	120 Packs	70
2	7566K25 Cable Tie Mount, Adhesive/Fastener Mount, 4 Way, 0.21" Tie WD. , White, Packs of 50	1 Pack	1
4	92311A639 18-8 Stainless Steel Cup Point Set Screw, 3/8"-24 Thread, 1" Long, Packs of 10	5 Packs	5
5	93695K58 Oil-Resistant Neoprene/Vinyl/Buna-N Foam, Adhesive-Back, 1/4" Thick, 1" Width, 50' L, Black	1 Each	1
6	6718K52 Stainless Steel Industrial-Shape Hose Coupling, Plug, 1/4" NPTF Female, 1/4 Coupling Size	10 Each	10
8	4443A33 12-Volt Lithium Ion Battery for, Milwaukee Cordless Tool	1 Each	1
10	5682A81 Premium Plastic-Handle Screwdriver, 1/4" Tip Width, 4" Long Slotted Round Blade	2 Each	2
11	5443A28 Miniature Inch Combination Wrench, 12 Point, 5/16" Size, 3-1/2" Overall LG. , Chrome Finish	2 Each	2
12	3672K17 Steel Precision V-Groove-Guided Track Roller, Standard Stud, 20 mm Roller Diameter	3 Each	3
13	99142A540 Black-Finish Steel Internal Retaining Ring, for 1-1/2" Bore Diameter, Packs of 25	1 Pack	1
14	8635K171 Medium-Strength Oil-Resistant Buna-N Rubber, Plain Back, 1" Thick, 12" X 12", 50A Durometer	1 Each	1
15	7856K15 Heat-Shrink Tubing, 1/4" ID Before, 1/8" ID After, 4' L, Black	1 Each	1
16	7856K16 Heat-Shrink Tubing, 3/8" ID Before, 3/16" ID After, 4' L, Black	1 Each	1
17	7856K14 Heat-Shrink Tubing, 3/16" ID Before, 3/32" ID After, 4' L, Black	1 Each	1
18	7196K41 Straight-Blade, Three-Blade Female Connector, NEMA 5-15	3 Each	3
19	4429K154 Low-Pressure Brass Threaded Pipe Fitting, 3/4 Pipe Size, 90 Degree Female X Male Elbow	4 Each	4
20	4568K194 Standard-Wall Brass Threaded Pipe Nipple, 3/4 Pipe Size X 3" Length	2 Each	2
21	47865K24 Brass Ball Valve, 3/4" NPT Female Connections	2 Each	2
22	73605T93 Brass Garden Hose-to-Pipe Rigid Adapter, 3/4" Male Garden Hose, 3/4" NPT Female Connections, Packs of 1	2 Packs	2

16/2/20
Siv



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO31460**

Purchase Order Date 2/23/2016

PO Print Date 2/24/2016

Page Number 2 of 9

Order From :

MCMaster-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

VU-MCM001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

330 995 5500

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

Purolator ground ppd

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 10

USD

FCA - (Free Carrier)

4

92311A639

SS SET SCREW

2/26/2016

Yes

2/26/2016

50.00

Each

Line Total:

\$104.32

AS PER DWG D2747 REV. B
B141990

\$0.63

\$31.30

5

93695K58

WINDOW SEAL

2/26/2016

Yes

2/26/2016

50.00

f

Line Total:

\$31.30

AS PER DWG D3802 REV. D
B141991

\$0.31

\$15.40

6718K52

Fitting, Quick Disconnect

2/26/2016

Yes

2/26/2016

10.00

Each

Line Total:

\$15.40

AS PER DWG D4182 REV. B
B141986

\$5.81

\$58.10

162/26
SP

Note:

2/24/2016